

# Work Order ID 81687

**\*81687\***

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March-16-12 1:59:12 PM

Item ID: D205-641-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ground Handling Wheel  
 Start Date: 16/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 30/03/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI 9536	A								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D205-641 bluefile & type labels per PPP D205-641-011 CHG002 JB								
110		0.00							
<b>*110*</b>	Pick Kit								
Packaging	Memo	0.00							
Packaging									
120		0.00							
<b>*120*</b>	QC- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

② MLJ 12-06-04  
 JB for MLJ 12-6-4  
 ④  
 4 12/06/01 JB  
 4 MLJ 12-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81687****\*81687\***

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Item ID: D205-641-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Ground Handling Wheel

Start Date: 16/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-641-011

Location: *AG**446/4 (4)*

140

0.00

**\*140\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*12/6/10**MF*  
*12-0005*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*81687\***

**\*D205-641-011\***

**Required Date:** 30/03/2012

**Required Qty: 4.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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**\*\***

121310 JB 54

**Loc Code**

32

**\*\***

82874 JB 54

**Loc Code**

4

**\*\***

1x82032 ✓ JB 12/06/01  
1x82031 ✓  
2x83896 ✓

**Loc Code**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81687

\*81687\*

Parent Item: D205-641-011

\*D205-641-011\*

Parent Item Name: Ground Handling Wheel

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D3405-043

Manufactured No

110

Each

16.0000

1

4

\*D3405-043\*

Lug Assembly

\*\*

83897 JB

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST478

14

78889

12

78890

2

MS21042L4

Purchased

No

110

Each

5,519.000

4

16

\*MS21042L 4\*

Nut

\*\*

JB 12/06/01

Location

Loc Qty

Loc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

121011

S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F AND  
INSTALLATION INSTRUCTIONS D204-635 REV. F

REF. TCCA STC SH96-88

REF. FAA STC SR00563NY

REF. EASA STC EASA.IM.R.S.01303

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 81687ML5

12/03/16

## PURPOSE:

THE PARTS LIST OF INSTALLATION INSTRUCTIONS D205-634 REV. F AND D204-635 REV. F LISTS THE  
INCORRECT PART NUMBER FOR THE BOLT PROVIDED WITH D205-641-011 GROUND HANDLING KIT.  
THE CORRECT PART NUMBER FOR THE BOLT IS AN4C46A.

## CHANGE:

THE PART NUMBER IN SECTION 5.0 OF D205-634 REV. F AND D204-635 REV. F AND SECTION 32.9 OF  
ICA-D204-635 REV. 3 IS AMENDED AS FOLLOWS:

### 5.0 PARTS LIST (D205-634 REV. F)

Item	634 -011	634 -015	634 -041	634 -045	641 -011	PART NUMBER	DESCRIPTION
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT

## IS:

52					4	AN4C46A	BOLT
----	--	--	--	--	---	---------	------

## WAS:

52					4	AN4C47A	BOLT
----	--	--	--	--	---	---------	------

### 5.0 PARTS LIST (D204-635 REV. F)

### 32.9 PARTS LIST (ICA-D204-635 REV. 3)

Item	635 -011	635 -041	641 -011	PART NUMBER	DESCRIPTION
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT

## IS:

52			4	AN4C46A	BOLT
----	--	--	---	---------	------

## WAS:

52			4	AN4C47A	BOLT
----	--	--	---	---------	------

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.11.26  
CERT. NO.: SH96-88  
ISSUE NO.: 3

A	NEW ISSUE (REF. CAR10-27)	MB	10.11.26
REV.		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9536	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		P/N CORRECTION	NTS
DATE	10.11.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

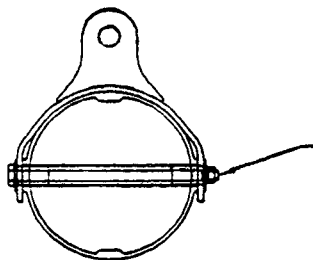
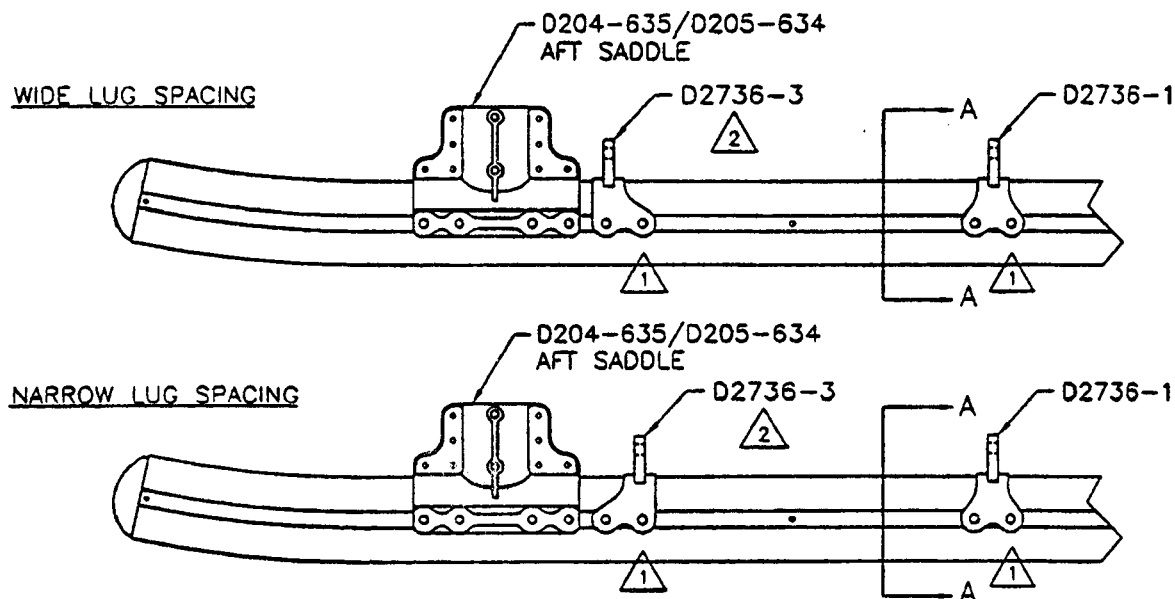
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# REFERENCE ONLY

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D205-641	REV. C SHEET 1 OF 1
DATE 97.12.17		TITLE GND HANDLING WHEEL (GHW) INST.	SCALE NTS
A	96.12.04	NEW ISSUE	
B	97.06.30	ADD MECHANICAL LOCK	
C	97.12.17	RE-DESIGN TO 2 SEPARATE LUGS	

TO ADAPT STANDARD BELL GROUND HANDLING WHEELS TO DART 204/205/212/412 SKIDTUBES, INSTALL THE D2736-1 & D2736-3 LUG ASSEMBLIES AS SHOWN BELOW.



VIEW A-A

AN4-46A BOLT (1)  
D2570 BUSHING (2)  
MS21042L4 NUT (1)  
(4 PLACES)

- 1 THESE HOLES DO NOT EXIST IF AN EARLY MODEL SKIDTUBE IS BEING RETRO-FITTED. DRILL  $\phi 0.438$  HOLE @ 1.750 FROM CENTER OF PREVIOUS HOLE, DE-BURR, AND TOUCH-UP WITH ZINC CHROMATE PRIMER.
- 2 D2736-3 LUG MAY BE INSTALLED IN EITHER ORIENTATION TO PROVIDE THE WIDE OR NARROW LUG SPACING AS REQUIRED BY DIFFERENT TYPES OF GROUND HANDLING WHEELS.

D205-641 GROUND HANDLING WHEEL ADAPTORS MAY REMAIN INSTALLED DURING FLIGHT ON D205-634 & D204-635 SKIDTUBE INSTALLATIONS. IF INSTALLED THE WEIGHT AND BALANCE INFORMATION IS AS FOLLOWS:

	WEIGHT	LONG. ARM	MOMENT
205/212/412 SKIDTUBES (D205-634)	2.0 lb 0.9 kg	148.2 in 3.76 m	296 lb in 3.38 kg m
204 SKIDTUBES (D204-635)	2.0 lb 0.9 kg	135.3 in 3.44 m	271 lb in 3.10 kg m